

Work Order ID 98018

March-04-13 7:39:15 AM

98018

Page 1

Item ID: DSK081

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: D2940-1 TURNING DETAIL

Start Date: 3/04/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 3/18/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: *ML5*

Date: *13-03-04* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSK081	B								
100		0.00							
100	MORI SEIKI CNC LATHE LARGE								
Doosan	Memo	0.00							
Doosan Lathe	Turn blank as per Folio FA079								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
120	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

DAS
04
2-83

DAS
04
2-83

FAI 13/03/13

Work Order ID 98018

98018

Page 2

Item ID: DSK081

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: D2940-1 TURNING DETAIL

Stop *NS2*

Start Date: 3/04/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 3/18/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

Packaging

0.00

Packaging

Memo

Packaging

Identify and Stock in KanbanLocation MAT 060

13/03/18

10 0

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

Quality Control

0.00

13/3/14

13-03-13

Picklist Print

March-04-13 7:39:19 AM

Page 1

Work Order ID: 98018

98018

Parent Item: DSK081

DSK081

Parent Item Name: D2940-1 TURNING DETAIL

Start Date: 3/04/13

Required Date: 3/18/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-007		Manufactured	No				Each	22.0000		10			

D6104-007

Round Billet, 17-4

**

Location

Loc Qty

Loc Code

MAT043

22

88959

22

83687

13-3-5

DAS
04
9-89

8

2

DART AEROSPACE LTD		Work Order:	98018
Description: Turning Detail for D2940-1		Part Number:	DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.215	3.215	3.215	3.215	3.215
B	4.946	4.966		4.955	4.955	4.955	4.955	4.955
C	0.718	0.738		.728	.728	.728	.728	.728
D	0.090	0.110		.097	.097	.097	.097	.097
E	3.564	3.584		3.576	3.576	3.576	3.576	3.576
F	0.022	0.042		.032	.032	.032	.032	.032
G	3.444	3.464		3.455	3.455	3.455	3.455	3.455
H	0.112	0.132		.120	.120	.120	.120	.120
I	2.170	2.190		2.180	2.180	2.180	2.180	2.180
J	4.451	4.471		4.464	4.464	4.464	4.464	4.464
K	0.413	0.433		.420	.420	.420	.420	.420
L	0.913	0.933		.923	.923	.923	.923	.923
M								
N								
O								
P								

Measured by: DAS 04 Date: 13.3.5

Audited by: FK Date: 13/03/13

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<u>[Signature]</u>

DART AEROSPACE LTD		Work Order:	98018
Description: Turning Detail for D2940-1		Part Number:	DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

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B	4.946	4.966		4.955	4.955	4.955	4.955	4.955
C	0.718	0.738		.728	.728	.728	.728	.728
D	0.090	0.110		.097	.097	.097	.097	.097
E	3.564	3.584		3.576	3.576	3.576	3.576	3.576
F	0.022	0.042		.032	.032	.032	.032	.032
G	3.444	3.464		3.455	3.455	3.455	3.455	3.455
H	0.112	0.132		.120	.120	.120	.120	.120
I	2.170	2.190		2.180	2.180	2.180	2.180	2.180
J	4.451	4.471		4.464	4.464	4.464	4.464	4.464
K	0.413	0.433		.420	.420	.420	.420	.420
L	0.913	0.933		.923	.923	.923	.923	.923
M								
N								
O								
P								

Measured by: DAS 04 Date: 13.3.13

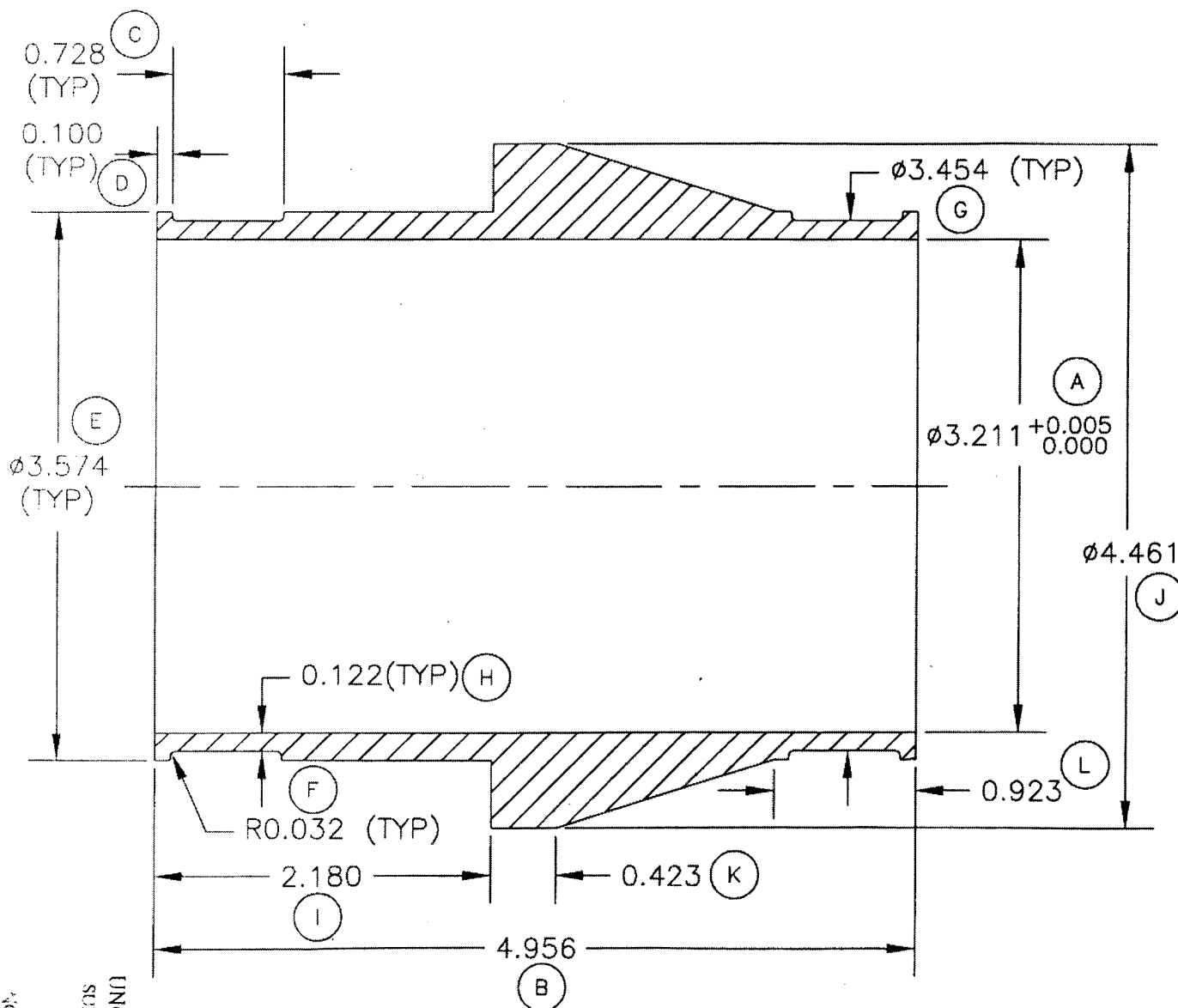
Audited by: EK Date: 13/03/13

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>



DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 081	REV. B SHEET 1 OF 1
DATE 03.06.24		TITLE TURNING DETAIL FOR D2940-1	SCALE 1:1
A	03.03.07	NEW ISSUE	
B	03.06.24	ADDED 4.956 DIMENSION	



D2940-1 TURNING DETAIL

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13-08-04

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SHEET 1 OF 1